

FIG. 1

Apply foamable plastic layer containing a foaming agent over a sheet substrate.

Heat to gel the plastic layer without activating the foaming agent.

Apply a first printing ink containing a photoinitiator in a first pattern on the gelled plastic layer.

Apply a second printing ink containing a photoinitiator and an expansion inhibitor in a second pattern on the gelled plastic layer.

Apply a clear liquid plastisol coating containing a UV curable photopolymer over the gelled plastic layer and first and second printing inks.

Gel the plastisol coating by heating the plastisol to a temperature below 340°F.

Soften the gelled plastisol coating by heating the surface below 340°F.

Mechanically emboss the softened plastisol with a textured roll such as that imitating the texture of grout or mortar.

Expose the plastisol to UV light to set the texture in those portions of the plastisol overlying the first and second printing containing a photoinitiator.

Fuse the product in a fusion oven by heating. That portion of the plastisol which does not overlie the printing inks containing a photoinitiator smooths out.

Mechanically emboss the surface of the plastisol which has smoothed out with a texture imitating the texture of stone, wood, or the like.

Optionally coat the product with acrylic polyurethane.

FIG. 2

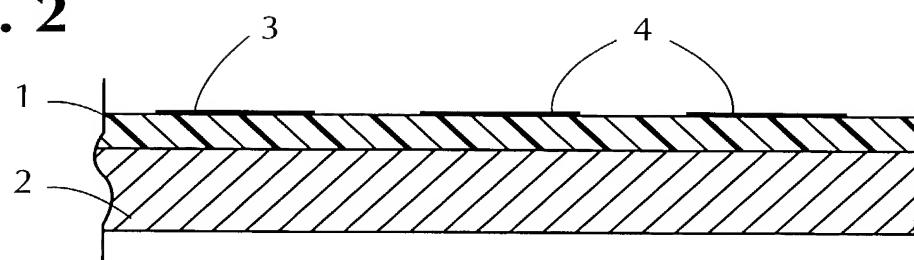


FIG. 3

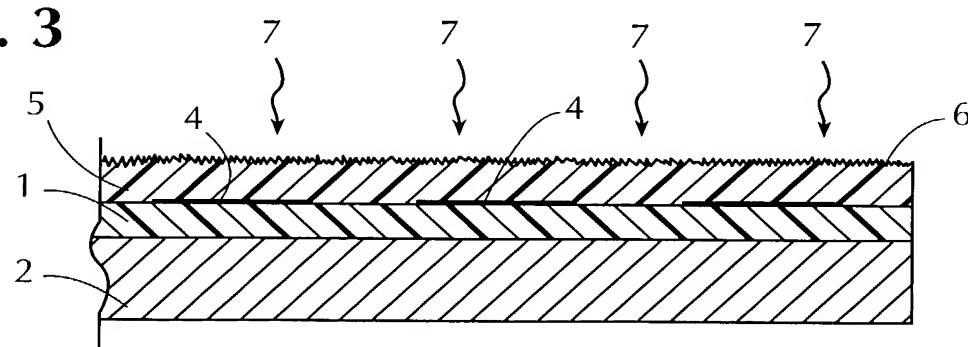


FIG. 4

